

We claim:

1. A method for making a decorated, extruded wall base, said method comprising the steps of:

extruding from an extruder die heated, flexible plastic or rubber extruded base layer having a profile;

passing said base layer through at least one chilling bath to cool the base layer;

removing water adhered to said base layer;

pulling said base layer by at least one variable speed puller from the extruder die, the speed of the puller being controlled according to the tension of said base layer;

providing a heat transfer film comprising a carrier layer carrying heat transfer layers including an ink transfer layer;

passing said base layer into a conveyor roller press having opposing top and bottom rollers, said base layer passing between said opposing top and bottom rollers;

passing said film into said conveyor roller press between said opposing top and bottom rollers, and heating at least one of said rollers to a temperature to enable the removal of the heat transfer layers from the carrier layer;

passing the heat transfer film between the top roller and a bottom roller;

applying pressure between the opposing rollers to apply pressure to the moving, flexible base layer and the moving heat transfer film moving between said rollers to transfer the heat transfer layers from the carrier layer to the base layer;

pulling the wall base through an air-cooling system by a second puller;

peeling the carrier layer from the heat transfer layers; and  
withdrawing the decorated extruded wall base.

2. The method according to claim 1 further comprising repeating, at least once, the steps of bringing together, pushing together and adhering using additional top and bottom rollers.

3. The method according to claim 2, wherein at least one additional top roller is tilted to create pressure on a portion of the profile to which no pressure was applied by the prior top and bottom rollers and additional top and bottom rollers, said tilting for ensuring proper coverage of the ink transfer foil.

4. The method according to claim 1 wherein the temperature of said extruded base layer is at least 320°F prior to passing through said first water bath.

5. The method according to claim 1 wherein said top roller is 60 to 70 durometer silicone rubber.

6. The method according to claim 1 wherein said bottom roller is aluminum.

7. The method according to claim 1 wherein said bottom roller is rubber.

8. The method according to claim 1 wherein said top roller and said bottom roller match the profile of the base layer.

9. The method according to claim 1, wherein said film layer is between 0.0159 inches and 0.0191 inches.

10. The method according to claim 1, wherein the temperature of said top roller is between 225°F and 450°F.

11. The method according to claim 1, wherein said conveyor rolling press includes a dual head foil transfer with ultrasonic tension control.

12. A method for making a decorated, extruded wall base having a base layer and a film layer having a design layer and a carrier layer, the design layer being heat transferable from the carrier layer, said method comprising the steps of:

heating a top roller to a temperature beneath the melting point of the base layer;

bringing together the base layer and the film layer between said heated top roller and a bottom roller;

pushing together said rollers to apply pressure to the base layer and the film layer while said layers are between said rollers;

adhering, by heat from said heated top roller and by pressure from said pushed together top and bottom rollers, said design layer to said base layer;

pulling the wall base through an air-cooling system; and

peeling off the carrier layer from the film layer of the wall base.

13. A system for adding ink transfers to a movable flexible plastic or rubber strip, said system comprising:

a flexible plastic or rubber extruded base layer having a profile;

a heat transfer film having a carrier layer comprising heat transfer layers including an ink transfer layer;

at least one conveyor roller press, each press having opposing top and bottom rollers, at least one of said opposing rollers being heatable to a temperature to enable the removal of the heat transfer layers from the carrier layer; and

an air-cooling system, wherein:

the base layer and the heat transfer film pass between the opposing rollers of at least one press and the opposing rollers of the at least one press apply pressure to the base layer and the heat transfer film transferring the heat transfer layers from the carrier layer to the base layer, separating the carrier layer from the heat transfer layers and creating a wall base; and

the wall base passes through the air-cooling system.

14. A decorated, flexible wall base comprising:

a flexible, plastic base layer; and

a heat and pressure impregnated decoration in a surface of said base layer, said decoration including an ink transfer transferred from a foil and having predetermined color, design and pattern features.

15. A wall base according to claim 14, wherein said decoration is applied to said flexible, plastic base layer as said base layer moves through a heat and pressure conveying system in conjunction with a moving carrier having a removable ink transfer layer.